

Work Order ID 57940

April 21, 2010 7:46:05 AM

Page 1

Item ID: D4037-3

Accept

Revision ID:

Item Name: Fwd Crossbeam

Start Date: 23/04/2010 Start Qty: 2.00

Required Date: 30/04/2010 Req'd Qty: 2.00

Reference:

10.04.21

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4037

B

MAT NOT PULLED

B10 4-26

①

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut blank as per file D4037-3_BLANK

110

0.00



HAAS I

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA878 AND DWG

FOLIO REV: B

DWG REV: B

DEBURR

SP 10/04/27

1

0

Work Order ID 57940

April 21, 2010 7:46:05 AM

Page 3



Item ID: D4037-3

Accept



Setup Start



Revision ID:

Item Name: Fwd Crossbeam

Stop



Start Date: 23/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

⇒ M 10/04/29

ⓧ ⓧ

Memo

START: 8:15AM
TEMP: 320°F
FIN 8:45AM

0.00

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

⇒ M-L w/04/29 ⓧ

Memo

170



Packaging

Packaging

Identify as per dwg & Stock Location.

0.00

0.00

Memo

16-4-29cf

Work Order ID 57940

April 21, 2010 7:46:05 AM



Page 4

Item ID: D4037-3

Accept



Setup Start



Revision ID:

Item Name: Fwd Crossbeam

Stop



Start Date: 23/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 30/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/04 JF
MF
10-4-29

Picklist Print

April 21, 2010 7:46:05 AM

Page 1

Work Order ID: 57940

Parent Item: D4037-3

Parent Item Name: Fwd Crossbeam

Comments: IPP REV:A NEW ISSUE 09-12-14 JLM VERIFIED BY:EC
REV:B AS PER REV B 10-04-19 JLM VERIFIED BY:EC

Start Date: 23/04/2010

Required Date: 30/04/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.000X15.00 0		Purchased	No			100	f	6.5000	8.2105			

6061-T6 Bar 1:00 x 15.00



B 104-26

D6102-005.
Apr 10-05-04

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT07

9544

6.5

6.5

~~M 105-58~~

B 33680

DART AEROSPACE LTD		Work Order: 57940
Description: CROSSBEAM		Part Number: D4037-3
Inspection Dwg: D4037	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

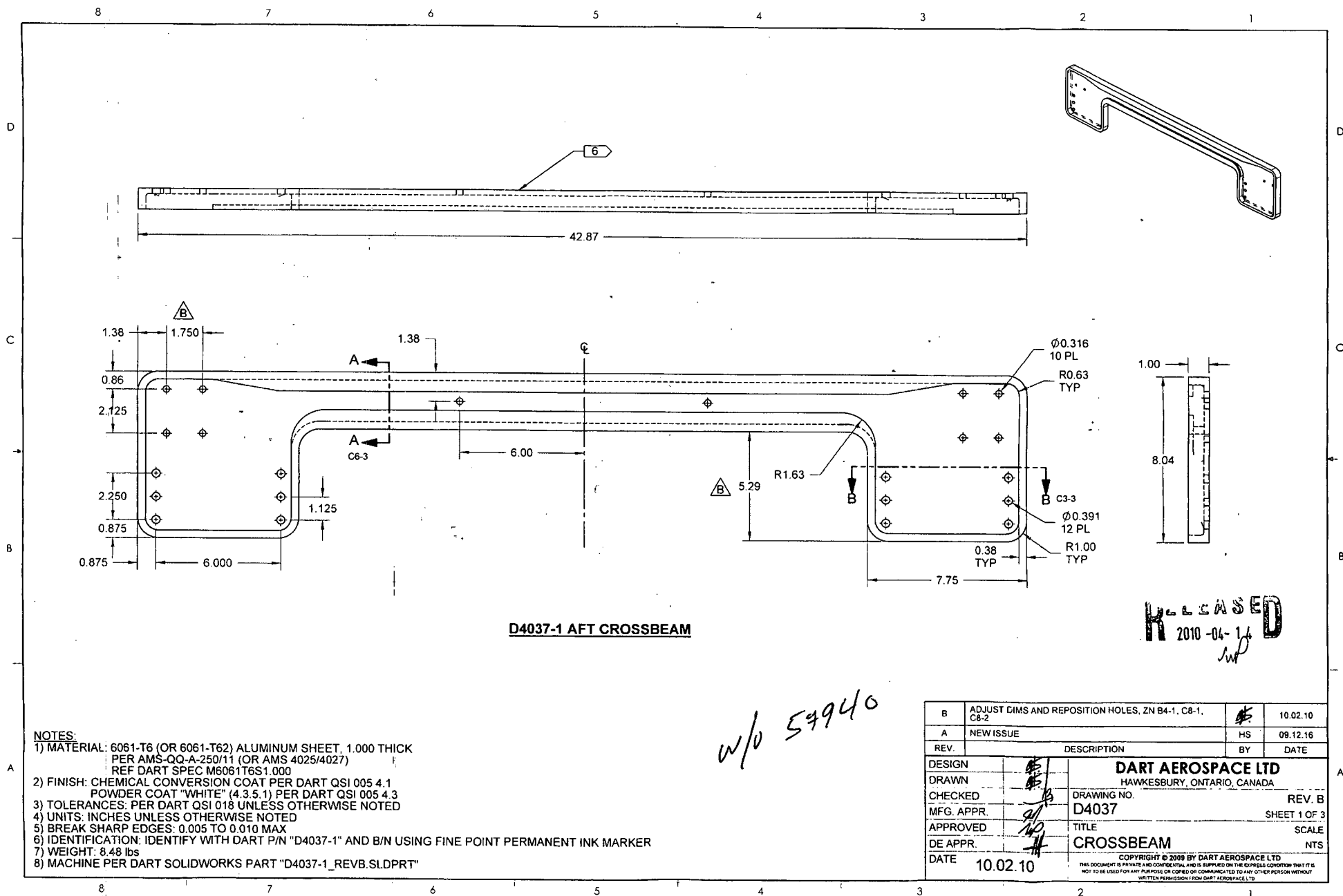
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.530	±.010"	.522	✓			
3.00	±.030"	3.01	✓			
2.00	"	2.010	✓			
1.00	"	1.017	✓			
.25	"	.265	✓			
.550	±.010"	.550	✓			
.550 .375		.372	✓			
1.750	"	1.748	✓			
2.125	"	2.124	✓			
2.250	"	2.249	✓			
1.125	"	1.123	✓			
6.000	"	5.996	✓			
7.75	±.030"	7.754	✓			
7.79	"	7.787	✓			
9.29	"	9.291	✓			
10.79	"	10.789	✓			
1.50	"	1.502	✓			
41.66	"	41.66	✓			
.28	"	.285	✓			
.92	"	.918	✓			
.92	"	.918	✓			
Ø.316	±.006"	.317	✓			
Ø.391	±.006"	.391	✓			

Measured by: <i>LF</i>
Date: 10/04/27

Audited by: <i>V</i>
Date: 10/04/27

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK
PER AMS-QQ-A-250/11 (OR AMS 4025/4027)
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4037-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 8.48 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4037-1_REV.B.SLDPRT"

w/o 59940

B	ADJUST DIMS AND REPOSITION HOLES, ZN B4-1, C8-1,	HS	10.02.10
A	NEW ISSUE	BY	DATE
REV.	DESCRIPTION		
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4037	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CROSSBEAM	NTS
DATE	10.02.10	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

- 3.4.7 Position the D2857-1/2 hinge brackets as shown in Figure 15(a) for the LH side and Figure 15(b) for the RH side. Transfer drill the $\varnothing 0.172$ " mounting holes on each bracket to the *Spacepod™* door. Install the hinge brackets as shown in Section J-J.

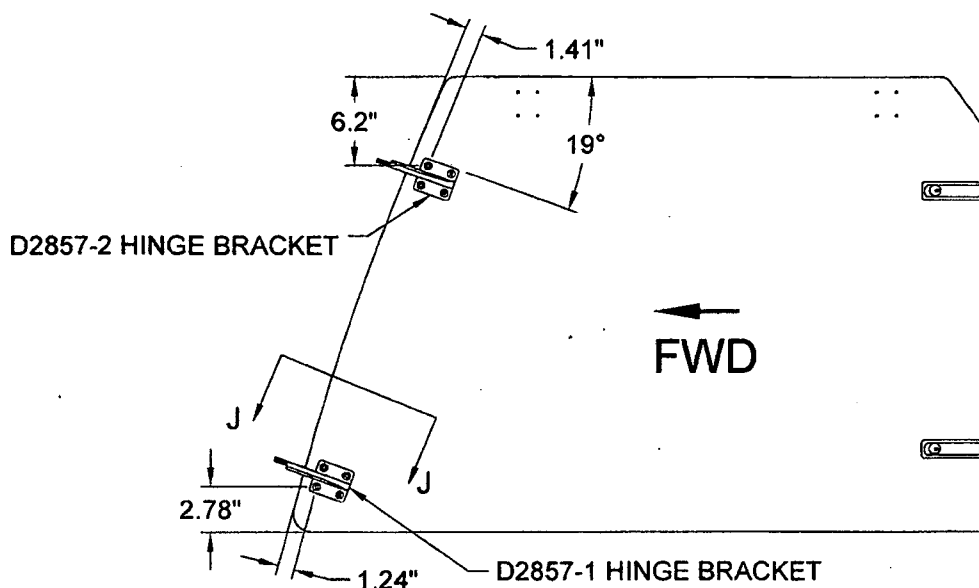


FIGURE 15(a) – HINGE BRACKET POSITION ON LH D3186-1 SPACEPOD™ DOOR

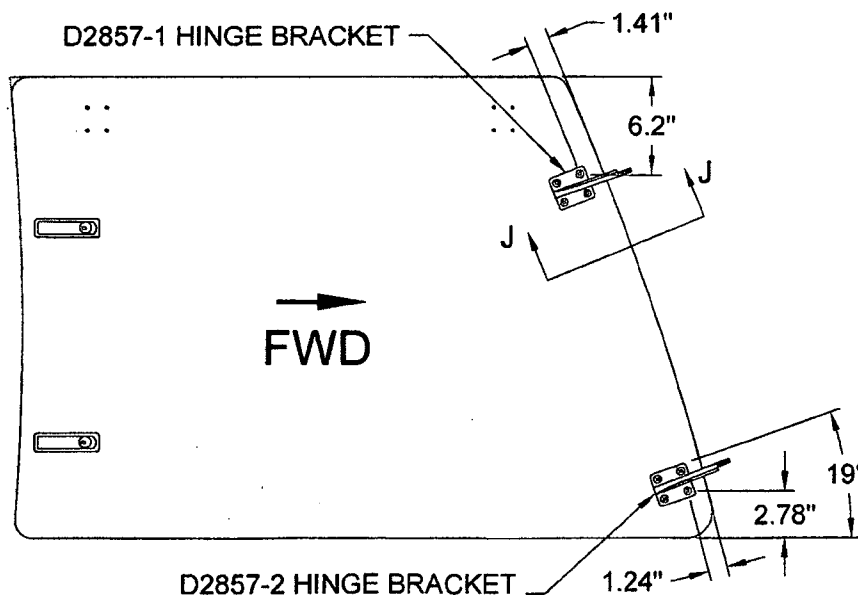
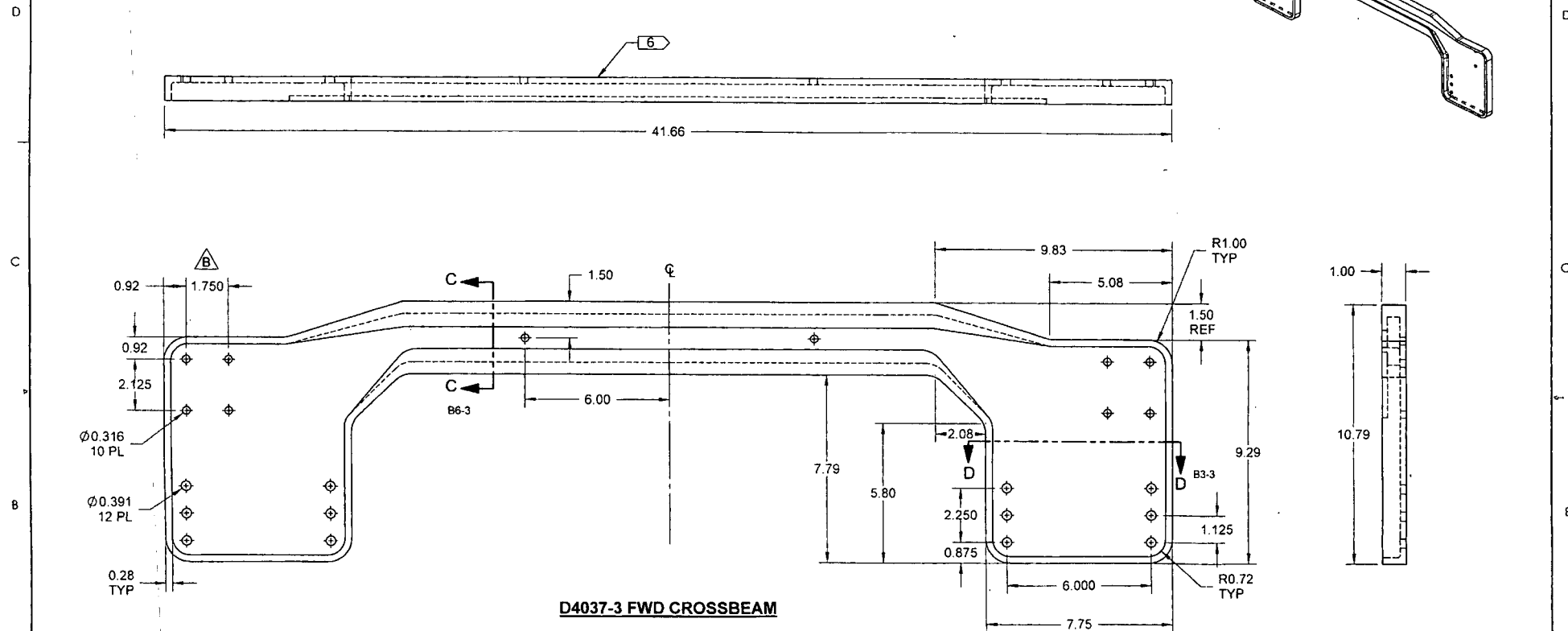


FIGURE 15(b) – HINGE BRACKET POSITION ON RH D3186-2 SPACEPOD™ DOOR

8 7 6 5 4 3 2 1



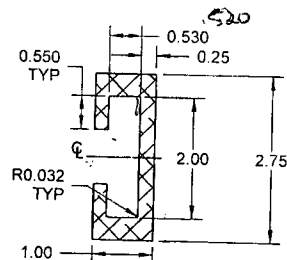
D4037-3 FWD CROSSBEAM

RELEASED
2010-04-14
NWP

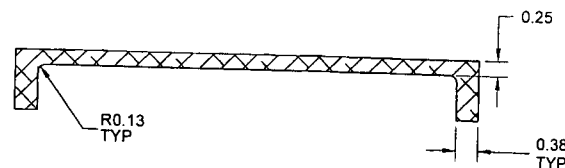
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK
PER AMS-QQ-A-250/11 (OR AMS 4025/4027)
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4037-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 9.17 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4037-3_REV.B.SLDPRT"

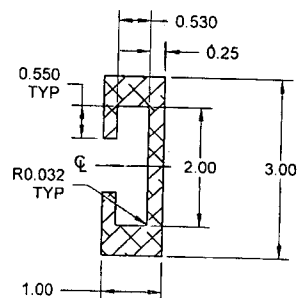
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4037	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CROSSBEAM	NTS
DATE	10.02.10	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



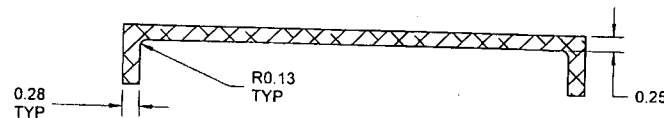
SECTION A-A B6-1
SCALE 2X



SECTION B-B B2-1
SCALE 2X



SECTION C-C B6-2
SCALE 2X



SECTION D-D B3-2
SCALE 2X

RELEASED
2010-04-16
JMP

w/o 57940

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4037	REV. B
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE CROSSBEAM	SCALE
DE APPR.			NTS
DATE	10.02.10	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	